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Canada

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Rush!!!

D5549-012
Job Sheet 185804



Part No: D5549-012

Job Qty: 1 ea

Part Name: Fwd Beam Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5549 REV.B IPP REV:A 18.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

007427

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Small Fab-4	5/4	JAN 10 2019 DAS
110	Small Fab	1 pcs	11/16/18	11/16/18	0.00	0.67	Small Fab-9		DAS
120	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC5		JAN 10 2019 68
130	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-2	5/477	JAN 11 2019 6 9-89
140	QC21-SA	1 Ea	11/16/18	11/16/18	0.00	0.00	QC21	1/2	JAN 11 2019 -89

Part Op 110 - 1- Install and Manufacture D2690-13 lanyard. 2- Install D5553-1 and D5554-3 with bolts and quick pin to Aft Beam.
Descriptions: Torque nut as per dwg. (see note 8) 3- Install D5550-041 to Aft Beam. Torque nut as per dwg. (see note 9)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-26A	Bolt	8 Ea (8 ea)	90-Start up Operation	50411275 513313122-
AN4-27A	Bolt	2 Ea (2 ea)	90-Start up Operation	50436181 505638571
CBL-1240	Cable	2.8000 ft (2.8 ea)	90-Start up Operation	5032061
CBL-460	Loop Sleeve	4 Ea (4 ea)	90-Start up Operation	5113790
D5549-1	Fwd Beam	1 Ea (1 ea)	90-Start up Operation	5121328
D5550-041	Fwd Outboard Beam Assembly	1 Ea (1 ea)	90-Start up Operation	5143712
D5553-1	Bracket	2 Ea (2 ea)	90-Start up Operation	5119977
D5554-3	Bracket	1 Ea (1 ea)	90-Start up Operation	5036043
MS17984-C625	Pin, Quick Release	2 Ea (2 ea)	90-Start up Operation	511138521
MS20002C6	Washer	6 Ea (6 ea)	90-Start up Operation	5088343
MS21042L4	Nut	10 Ea (10 ea)	90-Start up Operation	5130346
MS21042L6	Nut	6 Ea (6 ea)	90-Start up Operation	5107156
MS21250-06026	Bolt	6 Ea (6 ea)	90-Start up Operation	5133200 145127337x 2
NAS1149D0463J	Washer	20 Ea (20 ea)	90-Start up Operation	5129980
NAS1149D0663J	Washer	6 Ea (6 ea)	90-Start up Operation	5093765

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-26A	8	40	0
	AN4-27A	2	28	0
	CBL-1240	3	302	0
	CBL-460	4	313	0
	D5549-1	1	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

D5550-041	1	0	0
D5553-1	2	13	0
D5554-3	1	5	0
MS17984-C625	2	8	0
MS20002C6	6	104	0
MS21042L4	10	3,247	0
MS21042L6	6	326	0
MS21250-06026	6	12	0
NAS1149D0463J	20	4,159	0
NAS1149D0663J	6	1,035	0

Part Specifications

Specifications could not be found.

Plex 11/2/18 11:07 AM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S143913



Part: D5549-012
Job No. 185804
Serial No/Batch: S143913
Revision: E
Inspector:
Exp Date:
Instructions: Various STC's

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/10/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Chris Provencal

From: David Shepherd
Sent: Tuesday, November 13, 2018 12:22 PM
To: Chris Provencal
Subject: RE: NCR D5549-011 (D117-1044 Basket)

Chris,

As discussed, I agree that this deviation is acceptable.

Regards,
David

From: Chris Provencal
Sent: November 12, 2018 2:50 PM
To: David Shepherd <dshepherd@dartaero.com>
Subject: NCR D5549-011 (D117-1044 Basket)

David,

RE: D5549-011 Fwd Beam Assembly

The qty(1) pip pin hole in the D5549-1 Fwd Beam was misaligned with the D5553-1 Bracket that together captures the D5069 a/c attachment adapter (ref attached IIN.jpg). The misalignment was side-to-side and was enough to just prevent the pip pin from passing.

The $\varnothing 0.377+0.002/-0.000$ hole was opened with a $\varnothing 0.386$ reamer in the D5549-1 Fwd Beam (only) allowing the pip pin to pass thru. $\varnothing 0.386$ is the standard for a "close" fit for a 3/8" bolt.

The hole in the D5553-1 Bracket is unchanged, which is what captures the pip pin. Even if the pip pin were to be installed backwards, the $\varnothing 0.386$ hole doesn't allow the 0.440 wide pins to pass through without pushing the pip pin button. When assembled with the D5069-1 Adapter (attached photo), there is enough play in the entire system that the pip pin bears on all surfaces under load.

Would you agree that this is acceptable?

Sincerely,

Chris Provencal, P.Eng
Senior Engineer

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